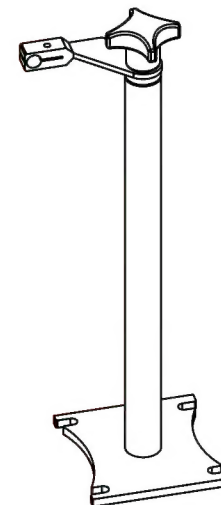
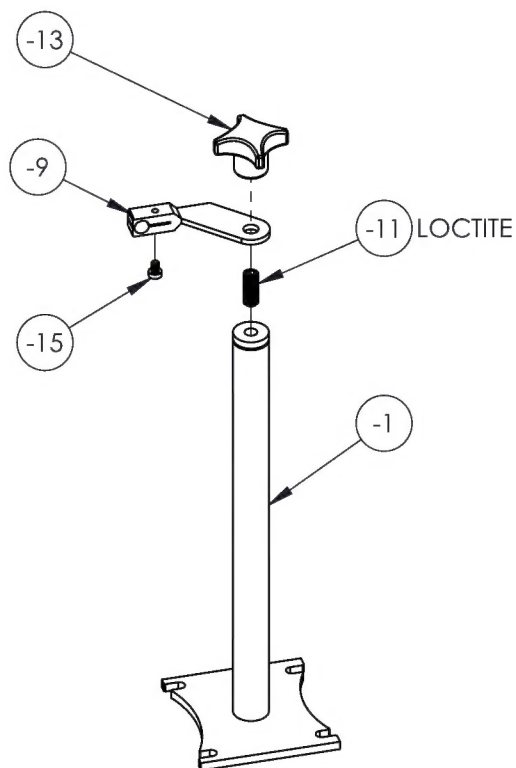


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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		RELEASED FOR PRODUCTION.	8/1/2016	RJC	JAG

**SEE ATTACHED DEVIATION**



NOTE:  
REF. EUROCOPTER T/N 105-31702W24.

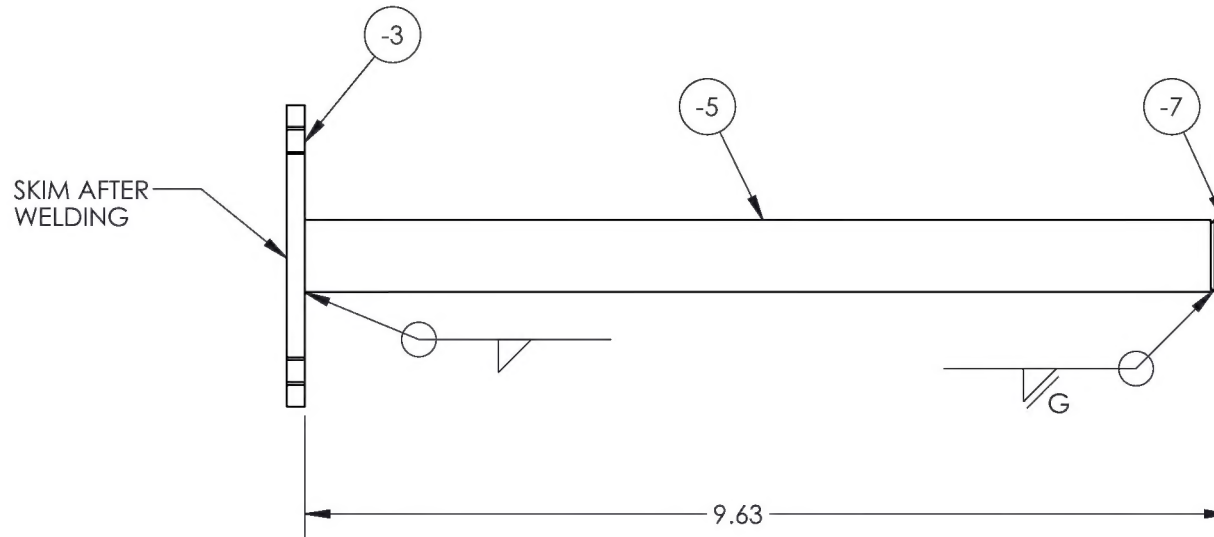
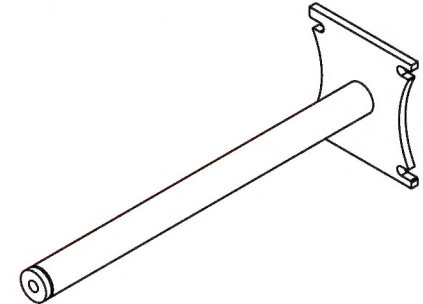


ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.	MEASURING DEVICE			
	X		-1	1	WELDMNT			2	DWG NO. RBE105-31702W24			REV. 1
	1		-3		BASE PLATE	A36/1018/1020 HR		3	MAT'L		UNLESS OTHERWISE SPECIFIED	
	1		-5		TUBE	DOM		4	HEAT TREAT		DIMENSIONS ARE IN INCHES	
	1		-7		CAP	A36/1018/1020 HR		5	FINISH		.XXX ± .005 FRACTIONS ± 1/8	
			-9	1	ARM	A36/1018/1020 HR		6	SPEC		.XX ± .01 ANGLES ± 5°	
		B/O	-11	1	SET SCREW	STEEL	M8 X 1.25 X 20mm (MCMASTER-CARR #93245A145)	1	DRAWN BY: CLOUGH		.X ± .1 SURFACES = 125/	
		B/O	-13	1	FOUR ARM KNOB	PHENOLIC	M8 X 1.25, 40mm (MCMASTER-CARR #6390K23)	1	CHECKED: DUERFELDT		1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
		B/O	-15	1	SOCKET HARD CAP SCREW	STEEL	M4 X .7 X 6mm (MCMASTER-CARR #90327A111)	1	OPPS APPR: ANDERSON		2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
	ASSY -1								QA APPR: LINDSAY		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
									APPROVED: GILBERT		USED ON MODEL EC145	
									SCALE 1:4		DATE 7/15/2016	
											SHEET 1 OF 6	

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REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED	

**SEE ATTACHED DEVIATION**



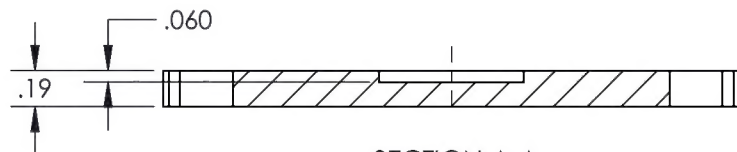
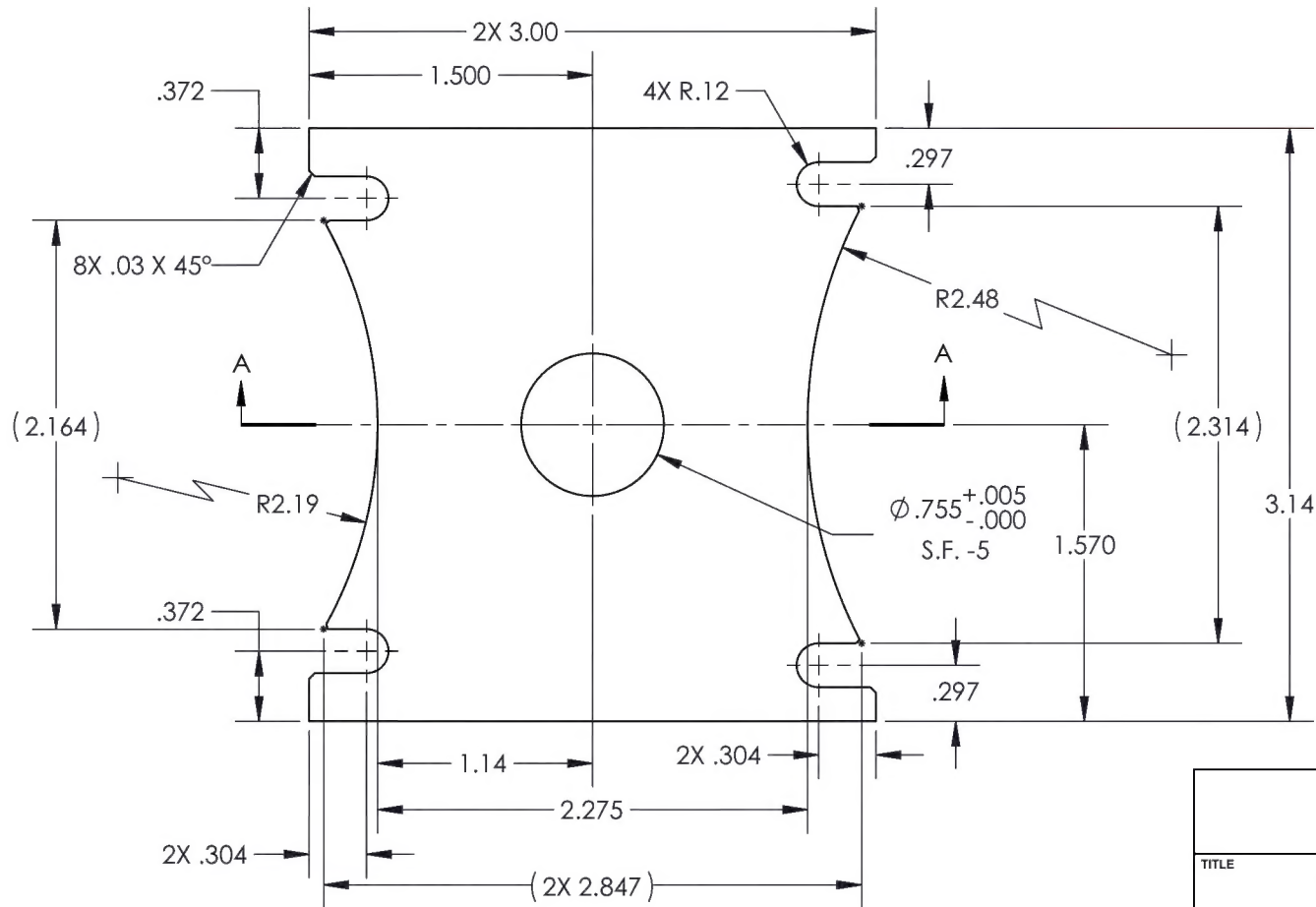
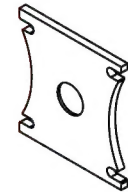
(-1)  
WELDMENT

<b>DART AEROSPACE</b>	
TITLE <b>MEASURING DEVICE</b>	
DWG NO. <b>RBE105-31702W24-1</b>	REV <b>1</b>
MAT'L <b>ZINC PLATE</b>	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± .5° .X ± .1 SURFACES = 125°
SPEC <b>ASTM B633 TYPE I SC 2</b>	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: <b>CLOUGH</b>	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: <b>DUERFELDT</b>	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: <b>ANDERSON</b>	USED ON MODEL
QA APPR: <b>LINDSAY</b>	<b>EC145</b>
APPROVED: <b>GILBERT</b>	
SCALE <b>1:2</b>	DATE <b>7/15/2016</b>
SHEET 2 OF 6	

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REVISIONS			DATE	INITIAL	APPROVED
REV	ECR	DESCRIPTION			

**SEE ATTACHED DEVIATION**



SECTION A-A

(-3)

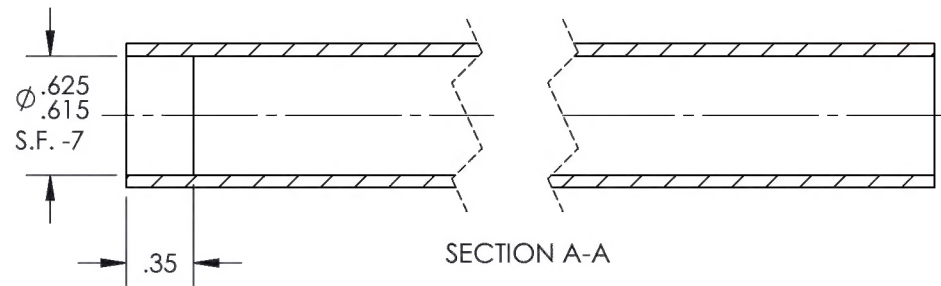
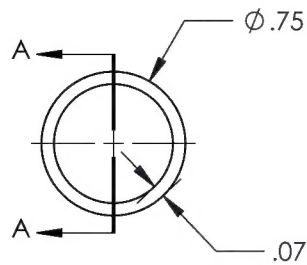
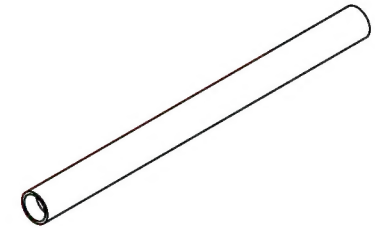
BASE PLATE

<b>DART AEROSPACE</b>	
TITLE <b>MEASURING DEVICE</b>	
DWG NO. <b>RBE105-31702W24-3</b>	REV <b>1</b>
MAT'L A36/1018/1020 HR HEAT TREAT FINISH SEE -1 SPEC	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125° ✓	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: <b>CLOUGH</b>	USED ON MODEL
CHECKED: <b>DUERFELDT</b>	EC145
OPPS APPR: <b>ANDERSON</b>	
QA APPR: <b>LINDSAY</b>	
APPROVED: <b>GILBERT</b>	
SCALE 1:1	DATE 7/15/2016
SHEET 3 OF 6	

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED

**SEE ATTACHED DEVIATION**



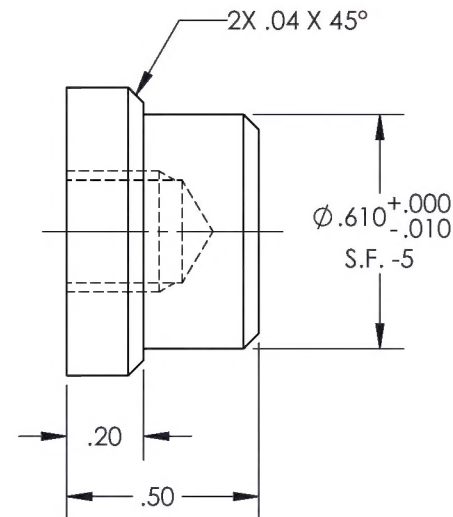
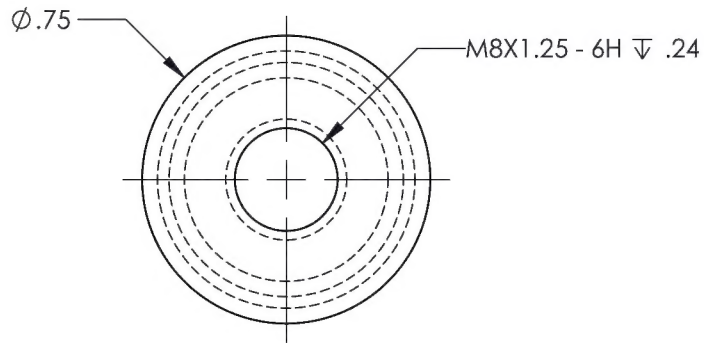
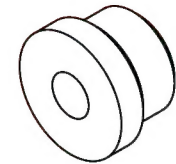
(-5)  
TUBE

<b>DART AEROSPACE</b>	
TITLE <b>MEASURING DEVICE</b>	
DWG NO. <b>RBE105-31702W24-5</b>	REV <b>1</b>
MAT'L DOM <b>HEAT TREAT FINISH SEE -1</b>	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± .5° .X ± .1 SURFACES = 125/✓
SPEC	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: <b>CLOUGH</b>	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: <b>DUERFELDT</b>	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: <b>ANDERSON</b>	
QA APPR: <b>LINDSAY</b>	USED ON MODEL
APPROVED: <b>GILBERT</b>	<b>EC145</b>
SCALE <b>1:1</b>	DATE <b>7/15/2016</b>
SHEET 4 OF 6	

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**SEE ATTACHED DEVIATION**



(-7)

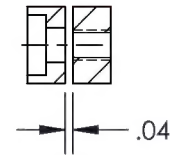
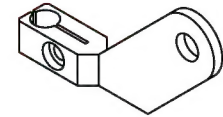
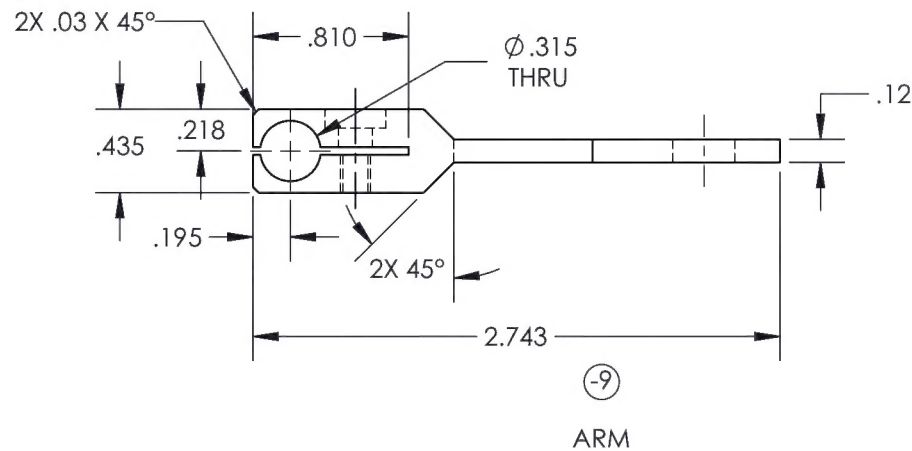
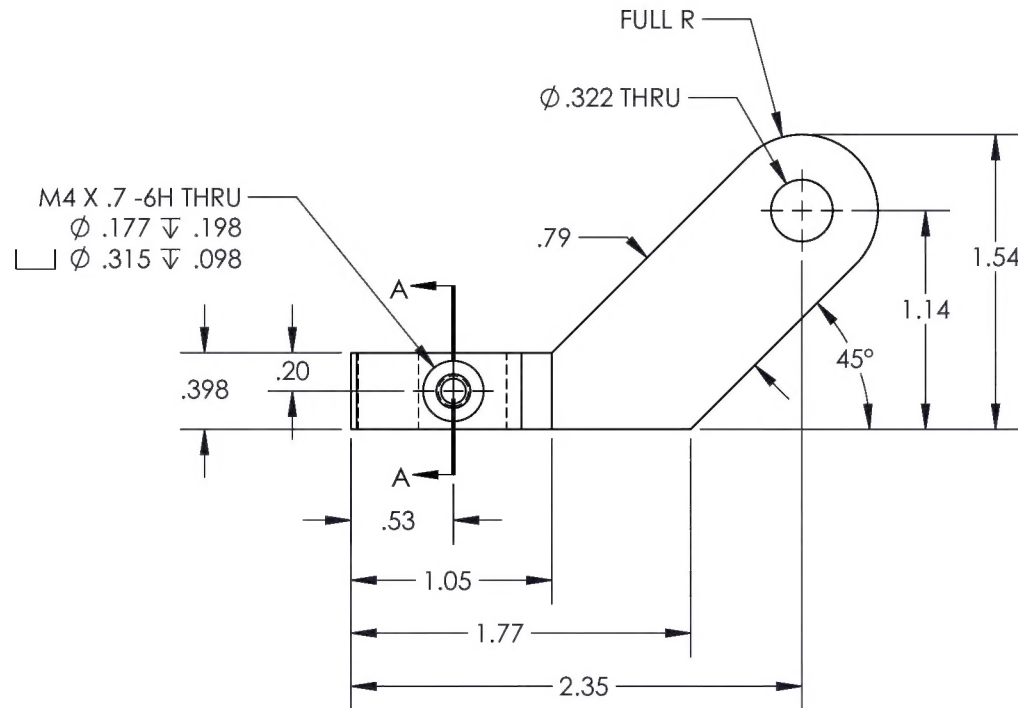
CAP

<b>DART AEROSPACE</b>	
TITLE <b>MEASURING DEVICE</b>	
DWG NO. <b>RBE105-31702W24-7</b>	REV <b>1</b>
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -1	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± 5°
	.X ± .1 SURFACES = 125✓
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES
CHECKED: DUERFELDT	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
	USED ON MODEL
	EC145
SCALE 2:1	DATE 7/15/2016
	SHEET 5 OF 6

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REV	ECR	DESCRIPTION			DATE	INITIAL	APPROVED

**SEE ATTACHED DEVIATION**



SECTION A-A

<b>DART AEROSPACE</b>	
TITLE <b>MEASURING DEVICE</b>	
DWG NO. <b>RBE105-31702W24-9</b>	REV <b>1</b>
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH ZINC PLATE	.XX ± .01 ANGLES ± .5°
SPEC ASTM B633 TYPE I SC 2	.X ± .1 SURFACES = 125° ✓
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	EC145
SCALE 1:1	DATE 7/15/2016
SHEET 6 OF 6	



Entered: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. \_\_\_\_\_

Route update only ☐

Job: _____  Part No. <u>RBE105-31702W24P Rev. 1</u>	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/>	<b>DEPARTMENT/PROCESS</b>  <div style="display: flex; justify-content: space-between;"> <div>             Skid-tube <input type="checkbox"/>              Machining <input type="checkbox"/>              Large Fab <input type="checkbox"/> </div> <div>             Cross tube <input type="checkbox"/>              Small Fab <input type="checkbox"/>              Finishing <input type="checkbox"/> </div> <div>             Eng. (Non-AW) <input type="checkbox"/>              Prod. Eng. Coord. <input type="checkbox"/>              Rec/Store/Packaging <input type="checkbox"/> </div> <div>             Engineering <input type="checkbox"/>              Water Jet <input type="checkbox"/>              Supplier <input type="checkbox"/>              Quality <input type="checkbox"/> </div> </div>		
Date :	Sequence #:	QTY Affected :	<b>MRB (QSI042)</b> December 7, 2018 	
<b>Description Work Order Deviation</b>		<b>Disposition</b>		<b>Completed By</b>
RBE105-31702W24-5 and -7 must be manufactured as one piece from 303/304 Stainless Steel rod.  RBE105-31702W24-3 must be manufactured from 303/304 Stainless Steel plate.  Zinc Plate is no longer required		This deviation is acceptable.  No change to fit form or function of the tool.		<b>Lead hand / Supervisor</b>
				<b>QC / QA Coordinator</b>
<b>Root Cause</b>		<b>FAULT CATEGORY</b>		
<div style="display: flex; flex-direction: column;"> <div>Operator <input type="checkbox"/></div> <div>Manufacturing Process <input type="checkbox"/></div> <div>Equip/Tooling <input type="checkbox"/></div> <div>Handling/Presservation <input type="checkbox"/></div> <div>Material <input type="checkbox"/></div> <div>Product Improvement <input checked="" type="checkbox"/></div> <div>Process Improvement <input type="checkbox"/></div> <div>Human Factors <input type="checkbox"/></div> </div>		<div style="display: flex; flex-wrap: wrap;"> <div style="width: 50%;"> <input type="checkbox"/> Pressure/Forced  <input type="checkbox"/> Bending  <input type="checkbox"/> Crushing  <input type="checkbox"/> Cracks  <input type="checkbox"/> Crimp/Kink/Ripple/Wave/Twist  <input type="checkbox"/> Marks/Chatter  <input type="checkbox"/> Mislabeled         </div> <div style="width: 50%;"> <input type="checkbox"/> Contamination  <input type="checkbox"/> Misaligned/off center  <input type="checkbox"/> BOM/Route  <input type="checkbox"/> Broken/Damage/Defect  <input type="checkbox"/> Incomplete/Unclear Instructions  <input type="checkbox"/> Drill Holes  <input type="checkbox"/> Fit/Function         </div> <div style="width: 50%;"> <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Folio/Program  <input type="checkbox"/> Grain Direction  <input type="checkbox"/> Weld  <input type="checkbox"/> Wrong Stock Pulled  <input type="checkbox"/> Out of Sequence  <input type="checkbox"/> Off-set/Set-up         </div> <div style="width: 50%;"> <input type="checkbox"/> Positioned Wrong  <input type="checkbox"/> Outside Tolerance  <input type="checkbox"/> Drawing  <input type="checkbox"/> Finish  <input type="checkbox"/> Part Lost/Missing  <input type="checkbox"/> Misread         </div> </div>		
Other/Details:				